

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001400**Date Inspected:** 29-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Mock-up**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Bay II**Tower Mock-up 114 M**

The QA inspector performed 10 % of Ultrasonic testing (UT) to the Tower Mock-up 114 M upper shaft, at the corner connection jointing the skin A and B. The QA inspector detected a rejectable indication located at Y location Y=330 from side B. See ultrasonic testing report TL_6027 generated on this date.

Bay I (OBG Deck)

The QA inspector performed random verifications of ZPMC fabrication activities for the first U-ribs. The QA inspector performed random verifications of bevel angles and root faces. The QA inspector observed that dimensions appeared to be in accordance with contract documents. The QA inspector observed that ZPMC QC inspector had not had the last revision of the ZPMC's fabrication procedure. The QA inspector asked ZPMC QC representative Fu Yu Hong and ABF representative about the deviation on the fabrication procedures. ABF representative said that neither ABF or ZPMC had received the last revision of fabrication procedure; However ABF, ZPMC and Caltrans knew about the last changes on the fabrication procedure since last friday. The QA inspector said that ZPMC supposed to perform a flatness check at the end of the joint and record the deviations. The QA inspector inform ABF representative that ZPMC has not done it. ABF, ZPMC representatives agreed to re-set the first 10 ribs fabricated on the leveled inspection table and perform the required dimensional inspections.

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The QA inspector said that the Caltrans QA inspectors needed to be present on ZPMC dimensional verifications. ZPMC informed that 1300 hours ZPMC was going to performed the dimensional inspection on this date. See TL_6031 from Bruce Berger for more information.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
